

Work Order ID 136773

Friday, September 04, 2015 1:51:01 PM

136773

Page 1

Item ID: D3847-049 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Wearplate Assembly, Float Gear
Start Date: 9/4/2015 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 9/18/2015 Req'd Qty: 6.00 ***6*** Customer:
Reference: REWORK PER ECN 14-628

Approvals: Process Plan: MP Date: 15-9-4 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3847	C								

210

0.00

210

QC

Quality Control

Memo

0.00

PULL FROM STOCK D3847-049 X 6:

2 X B88267 ✓

4 X B93904 ✓

BRING TO ANDY TO REMOVE GASKET, CLEAN AND REWORK TO
APPLY ROCK GUARD PER ECN 14-628**P.T.O.**

220

0.00

220

HandFinish

Hand Finishing

Memo

0.00

APPLY TEXTURE COATING ON TOP CONCAVE SURFACE AS PER DWG

TEXTURE COATING BATCH: 133152615-11-12

DQA: duf Date: 15/12/09



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☒

Work Order: <u>136773</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS				
Part No. <u>D3847-019</u>		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☒	
NCR No.		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
		Large Fab ☐	Composite ☐	Supplier ☐		

Date: 15.11.11 Step #: 100 QTY Effective: 6 MRB (QSI042) Approval A.P.

Description Work Order Deviation	Disposition	
Point stripper had to be used to remove excess glue from gasket	Repoint D3847-019 has per drawing. Powder coat Grey sandtex H Powder coat not required, dwg is being updated to reflect changes	15.11.11 Completed By DAS 41 15-11-11 9-89 Lead hand / Supervisor Approval Verification DAS 9 9-89 15-11-25 QC / QA Coordinator Approval DAS 9 9-89 15-11-10

Root Cause		FAULT CATEGORY			
Environment ☒	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☒	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	☒ Drawing
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			

Friday, September 04, 2015 1:51:01 PM

Page 2

ML3 NOV 16 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			

Root Cause	FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
☐ OTHER				

Picklist Print

Friday, September 04, 2015 1:51:01 PM

Page 1

Work Order ID: 136773

136773

Parent Item: D3847-049

D3847-049

Parent Item Name: Aft Wearplate Assembly, Float Gear

Start Date: 9/4/2015

Required Date: 9/18/2015

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP RevA: New issue DD verified by:EC

IPP REV:B

14.11.25 AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3847-049		Manufactured	No				Each	2.0000		6		DAS	
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D3847-049

Aft Wearplate Assembly, Float Gear

41
9-89

15-9-10

Location 88267

FP002 93904

135907

Loc Qty

2

2

Loc Code

2

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval
Description Work Order Deviation		Disposition			Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		☐ OTHER			

List Lots

Friday, September 04, 2015 1:24:39 PM

Page 1 of 1

Criteria : Item ID: d3847-049 All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt Lot Code	Type Code	Comments
D3847-049 Aft Wearplate Assembly, Float Gear	Main Warehouse FP002	135907	8/25/2015	2.0000	QC21		
	Main Warehouse FP002	88267	8/25/2015	2.0000	QC21		
	Main Warehouse ST606	93904	8/25/2015	4.0000	QC21		
Total:				8.0000			

#136773

DQA: _____ Date: _____



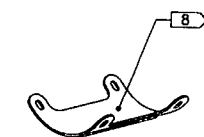
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

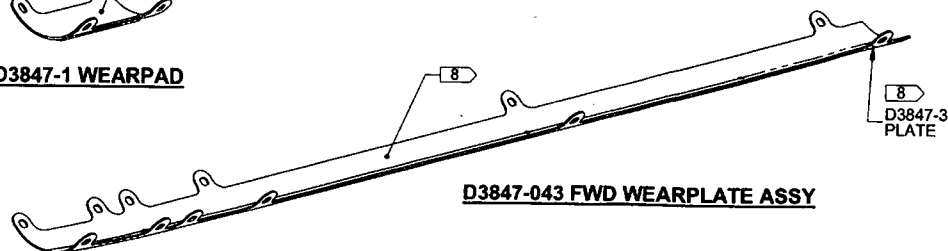
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Cratter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		☐ OTHER							

136773 MF

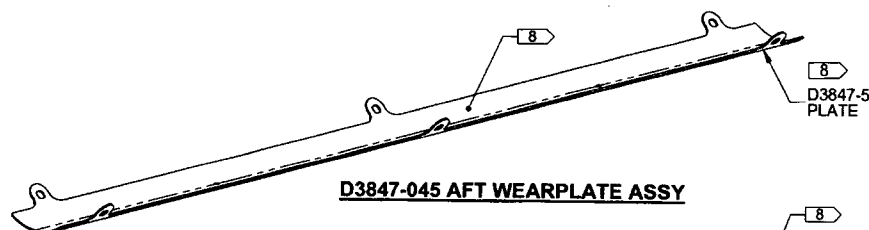


D3847-1 WEARPAD



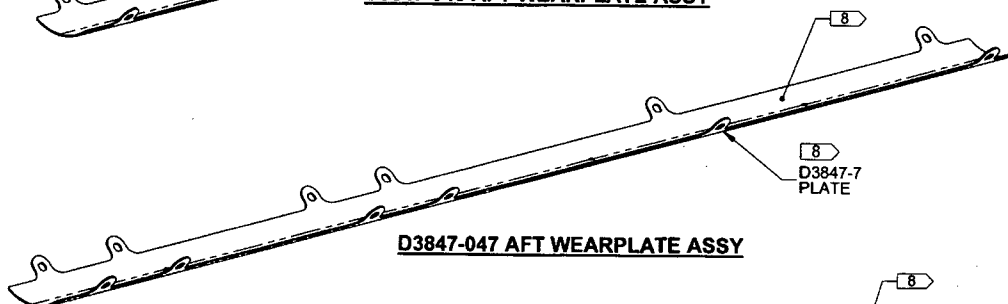
D3847-043 FWD WEARPLATE ASSY

8
D3847-3
PLATE



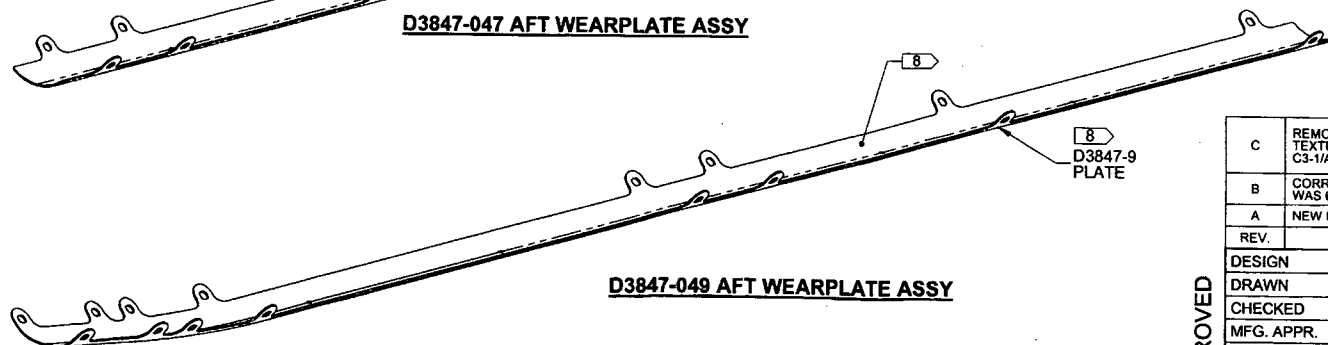
D3847-045 AFT WEARPLATE ASSY

8
D3847-5
PLATE



D3847-047 AFT WEARPLATE ASSY

8
D3847-7
PLATE

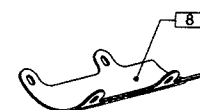


D3847-049 AFT WEARPLATE ASSY

ITEM	QTY -043	QTY -045	QTY -047	QTY -049	P/N	DESCRIPTION
1	X				D3847-043	FWD WEARPLATE ASSY, STD/FLOAT GEAR
2		X			D3847-045	CENTER WEARPLATE ASSY, STD/FLOAT GEAR
3			X		D3847-047	AFT WEARPLATE ASSY, STD GEAR
4				X	D3847-049	AFT WEARPLATE ASSY, FLOAT GEAR
11	1				D3847-3	PLATE
12		1			D3847-5	PLATE
13			1		D3847-7	PLATE
14				1	D3847-9	PLATE
31	A/R	A/R	A/R	A/R	TEXTURED COATING	SEALANT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3847-XXX"
USING YELLOW PAINT MARKER AT INSIDE SURFACE
- 7) WEIGHT: D3847-043 = 1.48 lbs
D3847-045 = 1.29 lbs
D3847-047 = 1.70 lbs
D3847-049 = 4.88 lbs
- 8) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING,
0.020-0.040 THICK, PER DART QSI 005 4.9



D3847-11 WEARPAD

RELEASED

2014 NOV 24
ECN 14-428

C	REMOVED D3846-3/-5/-7/-9 GASKETS, ZN D2-1. ADDED TEXTURED COATING, ZN B3-1. UPDATED WEIGHTS, ZN C3-1/A8-2	AK	14.08.06
B	CORRECT TYPO D3847-047 WAS D3847-045, ZN B5-1; 5.82 WAS 6.25 (ZN A4-2); 45.28 WAS 45.71 (ZN B4-5)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AK		
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3847	SHEET 1 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
DATE	14.08.06	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

APPROVED

DQA: _____ Date: _____

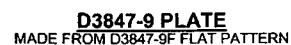


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER : _____																					



2014 NOV 24 4P

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR AMS 5524,
18 GAUGE (0.050 THICK), (REF. DART SPEC. M304S18GA)
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.86 lbs

DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AK		
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3847	SHEET 6 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
DATE	14.08.06	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS BEING SUPPLIED ON THE SUPPLIER'S CONFIDENTIALITY AGREEMENT. IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIALIZED TO ANY OTHER PERSON OR ENTITY WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.	

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